

Page 1

Thursday, May 13, 2010 10:25:25 AM

Item ID:

D3913-041

Accept



Setup Start



Revision ID:

Item Name:

Long Basket Base Assemby, 350

Start Date:

Required Date: 5/14/2010

5/13/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-5-13 Tooling:

Date:

Run

Start

Stop

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID Operation Description

Large Fab

Set Up/ **Run Hours**

Draw Number Draw Plan Code

Rev.

Accept Qty

Reject Qty

Reject Insp. Number Stamp

lpl 10.05.20 St 10/05/20

Draw Nbr

Revision Nbr

D3913

Α

100

Large Fab Large Fab

Memo

Memo

0.00

0.00

1- assemble ribs, weld as per dwg D3913 using DT9610A

inspect before welding mesh

Weld per dwg A/R S.S. rod Batch: 1/1/3328

2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

110

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

PD 10.05.20

0.00



| Dart | Aero | space | Ltd |
|------|------|-------|-----|
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| W/O: | | | W | ORK ORDER CHANGI | ES | | | | | | |
|----------|------|--------------------------------|----------------------|--|------------------------|---------------------------|-------------------------------------|--------------------------|--|--|--|
| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| Part No: | | | | | NCR: Yes No DQA: Date: | | | | | | |
| - | R | esolution: | | | | | Date: _ | | | | |
| NCR: | | | WORK ORI | DER NON-CONFORMA | NCE (NCR) | | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Corrective Action Section Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector | | | |
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Thursday, May 13, 2010 10:25:25 AM

Page 2

Item ID:

D3913-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 5/14/2010

Long Basket Base Assemby, 350

QC: ____

Start Date:

5/13/2010

Start Oty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

120



Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours Draw Number Draw Rev.

Plan Code

Reject Accept Qty Qty

Reject Number Stamp

Insp.

Memo

Sulvitzi

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

M114267

0.00

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder

=> Il 10/05/20 1

Memo

coat

START TIME: 9: 00 AM

OVEN TEMPERATURE: 400° /

2ND COAT: START TIME: 16:00 pm OVEN TEMPERATURE: 400%

FINISH TIME: 10:30

| Dart Aerospace I | Ltd |
|------------------|-----|
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| W/O: | | | WO | RK ORDER CHANG | ES | | | | ., | |
|-------------|----------------------------------|----------------------|---------------------------------|----------------|--------------|------------------|-------------|-----------------------|-------------------------------------|---|
| DATE | STEP | PRO | OCEDURE CHAP | NGE | В | у | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Categ | ory: | NCR: \ | ∕es N | o DQ | ⊥ A : | Date: | |
| | Re | esolution: | Disposition | : | QA: N/ | C Clos | sed: | • | Date: | |
| NCR: | | | | R NON-CONFORM | | | | | | |
| | | Description of NC | of NC Corrective Action Section | | | | \/!£'. | -41 | | |
| DATE | STEP Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | | gn & Date | Verific Secti | | Approval Chief Eng | Approval QC Inspector | |
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| Work Orde Thursday, May 1 | | | | | | | | | | | | Page 3 |
|---------------------------------|-----------|--|-------|--|--------------|-----------------|--------------|---------------|------------|---------------|------------------|----------------|
| Revision ID: | D3913-041 | | | Accept | | | | | Setup | | 1 | |
| | 5/13/2010 | Start Qty: 1.00 Req'd Qty: 1.00 | | | Cust Ite | | | | | Stop | | |
| Approvals: | | n: | Date: | | | Date: | | | Run | Start Stop | | |
| Sequence ID/ Work Center ID | | Operation Description QC3- Inspect Part Finish | | Set Up/ Run Hours | Draw Numb | Draw er Rev. | Plan Code | Accept Qty | Rej Qty | | Reject Number | Insp. Stamp |
| QC Quality Control | | Мето | | 0.00 =7 M | nd | 10/05 | 121 | |) | | | |
| 150 HandFinish Hand Finishing | | Assemble as per dwg Memo Pick Kit | | 0.00 · · · · · · · · · · · · · · · · · · | 0 05-21 | | | <u>a</u> | ···· | | | |

QC5- Inspect part completeness to step on W/O

0.00

160 QC

Memo

0.00

Quality Control

| Dart | Aer | ospa | ace | Ltd |
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| W/O: | | | W | ORK ORDER CHANG | SES | | | | | |
|---------|------|-------------------|----------------------|------------------------------|--------|----------------|---------------------------------------|------------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | egory: | _ NCF | R: Yes | No DQ | 4 : | _ Date: _ | |
| | | esolution: | | | | | | | | |
| NCR: | | | | ER NON-CONFORM | | | | | | |
| DATE | STEP | Description of NC | | | tion B | | Verific | ation | Approval | Approval |
| DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Secti | | Chief Eng | QC Inspector |
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Work Order ID 58658

Thursday, May 13, 2010 10:25:25 AM



Page 4

Item ID:

D3913-041

Accept

Setup Start



Revision ID:

Item Name:

Long Basket Base Assemby, 350

Start Date:

5/13/2010

Start Oty: 1.00

Reg'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

0.00

Date:

Start Stop

Stop



Required Date: 5/14/2010

Date:

SPC (Y/N):

Date:

Plan

Reject

Run

Reject

Insp.

Sequence ID/ **Work Center ID**

170

Packaging

Packaging

Operation Description

Memo

Set Up/ **Run Hours**

Draw Number

Code

Accept Qty Qty

Number

Stamp

180

OC

Quality Control

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release

Memo

Draw

Rev.

10/05/25/A)

| W/O: | | | W | ORK ORDER CHAN | GES | | | | | |
|-------------|------|-------------------|-----------------------------|------------------------------|---------|---------------|----------------|-----------|-------------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | E | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | egory: | NCR: | Yes N | lo DQ / | A: | Date: | |
| | | | | on: | | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORM | IANCE (| VCR) | | | | |
| DATE | STEP | Description of NC | Corrective Action Section B | | | | Verific | ation | Approval | Approval |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | | ign & Date | Secti | on C | Chief Eng | QC Inspector |
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|---|--|--|----------------------------|-------------------|-------------------------|--|------------------------|----------------------------|---------------------------|------------------------------------|---------------|------------------|----------|
| | Picklist Print Thursday, May 13, 2010 | 0 10:25:24 AM | | • | | - | | | | | | | Page 1 |
| | Work Order ID: 58658 Parent Item: D3913 | | | 12000 | | 88 (111 11 55 1) 88 1(1 9 (88) (16 | | | | | | | 6 |
| | Parent Item Name: Lo Comments: IP | ong Basket Base A P Rev:A new iss g qty's DD 10.04 | ue DD 10.03.19 | verified | | IPP Re | | | | tart Date: 5/13 Start Qty: 1.00 | | Required Date: : | |
| | Component Item ID/ Item Name AN3-10A | Replacement Item ID | Mfg/ Purch Purchased | Bin Item No | Primary Location | Last Location | Route Seq ID 150 | Unit of Measure Each | Qty on Hand 88.0000 | Qty per Kit | Qty Issued | Date Issued | Status |
| | | | | | <u>Locatio</u> | <u>n</u> | Loc | | Loc Code | | | | |
| | AN960JD8 | DN832 | Purchased | 1143 | ST351 SY8. | 114330 | 150 | 88 88 Each | 0.0000 | 2 | 6 | | |
| | Washer D2581 Mounting Bracket | | Manufactured . | No | | | 100 | Each | 36.0000 | 2 . | SY 10 | 105/17 | |
| | | | | | <u>Locatio</u> WA | 46086 51745 57185 58301 | <u>Loc</u> | Oty 36 2 2 9 23 | <u>Loc Code</u> | | 3 | | |
| | D2931 Bumper | | Manufactured | No | | 36301 | 150 | Each | 864.0000 | 2 | SAO | 10-05 | - 21 |
| | · | | | | <u>Locatio</u> ST504 | <u>n</u> 46064 | <u>Loc</u> | 864 864 | Loc Code | _ . – | <u> </u> | | |
| / | D3913-1 | W | Manufactured | No | | | 100 | Each | 1.0000 | | 3 <i>5</i> 85 | TAT O S | J 10/05/ |
| | | | | | Locatio | ņ | Loc | <u>Oty</u> | Loc Code | | | | |
| | | | | | WA | 58124 | | 1 | | | | | |

| W/O: | | | V | ORK ORDER CHAN | GES | | | | | |
|----------|------------|-------------------|----------------------|------------------------------|-------|----------------|--------------|------------|-------------------------------------|--------------------------|
| DATE | STEP | PRO | CEDURE CH | IANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Dort No. | | DAD # | | | | | | | | |
| Part NO | • | PAR #: | Fault Ca | tegory: | NC | R: Yes I | No DQ | A : | _ Date: _ | |
| | R | esolution: | | | | | | | Date: _ | |
| NCR: | | . V | ORK ORI | DER NON-CONFORM | IANCE | (NCR) |) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section B | | | Verific | ation | Approval | Approval |
| | V. | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Secti | | Chief Eng | QC Inspector |
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Thursday, May 13, 2010 10:25:24 AM

Work Order ID: 58658

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 5/13/2010

Oty per Kit

Start Qty: 1.00

Required Date: 5/14/2010

Required Qty: 1.00

Component Item ID/ Item Name D3913-15

Item ID

Replacement Mfg/

Purch Manufactured

Primary Bin Item Location No

Last Location Route Seq ID 100

100

Unit of Measure Each

Qty on Hand 11.0000

Issued

Otv

Date Status Issued

M 10/05/17

Wide Handle Plate

D3913-3 Rib

Manufactured No WA

Location

Location

Location

58127

WA

WA

58125

Loc Qty Loc Code 11 11 Each

2.0000

SM 10/05/17

✓ D3913-7

Rib

Manufactured No 58126

Loc Qty 2 2 100 Each

2.0000

Loc Code

B58579 @ St 10/05/17

✓ D3913-9 Hinge Rib

Manufactured No

2 2 100 Each

Loc Oty

Loc Code

2.0000

B 58582 (1) SM 10/05/17

Location WA 58128 Loc Qty 2 2

Loc Code

| Dart Ae | rospa | ce Ltd |
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| W/O: | | | V | ORK ORDER CHAN | GES | | <u></u> | | | |
|---------|------------------------|---------------------|----------------------|------------------------------|-------|----------------|----------|------|-------------------------------------|--------------------------|
| DATE | STEP | PR | OCEDURE CH | IANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | , | | |
| Part No | : | PAR #: | Fault Ca | tegory: | NCF | R: Yes I | No DQA: | | _ Date: _ | |
| | R | esolution: | Disposit | ion: | QA: | N/C CIO | sed: | | Date: | - |
| NCR: | | | WORK ORI | DER NON-CONFORM | MANCE | (NCR |) | | | |
| DATE | STEP Description of NC | | | Corrective Action Section B | | | Verifica | tion | Approval | Approval |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | 1 | Sign & Date | Section | | Chief Eng | QC Inspector |
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| NOTE: D | ı ate & initia | l al all entries | | | | <u>.</u> | | | ** | |

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Picklist Print

Thursday, May 13, 2010 10:25:25 AM

Work Order ID: 58658

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Comments:

Parent Item:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC

Start Date: 5/13/2010

Required Date: 5/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name D3916-041

Item ID

Replacement Mfg/ Purch Manufactured

Primary Bin Item Location No

Last Location

IPP Rev:B

Route Seq ID 100

100

Unit of Measure Each

Qty on Hand 2.0000

Qty Qty per Kit Issued 2

Date Issued

Status

Page 3

Rib Assembly

D3916-5

No

WA 58357

Location

Location

WA

Loc Qty 2 2

Loc Oty

Each

14.0000

Loc Code

10/05/17

B 58482

Light Rib

D4016-1 Hinge Half, Base

Manufactured No

Manufactured

14 57023 2 57982 9 58360 3 100

Each

9.0000

Loc Code

3

Rib

Manufactured No WA 58132

Location

9 100 Each

Loc Qty

4.0000

Loc Code

Location Loc Qty Loc Code WA 57989 2 58133 2

| W/O: | | WORK ORDER CHANGES | | | | | | | | | | |
|-------------|------|-----------------------------|-----------|--|-------------|--------------|-------------------------------|--------------------------|--|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | | | Ву | Date Q | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | |
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| Part No | | PAR #: | | | | | | | | | | |
| Resolution: | | esolution: | | | | | Date: _ | | | | | |
| NCR: | T | W | ORK ORI | DER NON-CONFORMA | NCE (NCR |) | | | | | | |
| DATE | STEP | Description of NC Section A | Initial | Corrective Action Section Action Description | on B Sign & | Verification | | Approval | | | | |
| | | Georgia A | Chief Eng | Chief Eng | Date | Section C | Chief Eng | QC Inspector | | | | |
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, May 13, 2010 10:25:25 AM

Work Order ID: 58658

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

Manufactured

Manufactured

Manufactured

chg qty's DD 10.04.12 verified by:EC



Start Date: 5/13/2010

Required Date: 5/14/2010

Date

Issued

Start Qty: 1.00

Qty per Kit

Qty

Issued

Required Qty: 1.00

Page 4

Status

Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Item Name Item Location Location Seq ID Measure Hand Item ID Purch D4017-9 No 100 Each 8.0000 Manufactured

No

No

No

Rib

D4020-1

Mesh (350 Basket Long, Base) D4020-11

End Mesh, Basket

D4021-1

Location Loc Qty Loc Code WA 58134 2 58415 100 Each 0.0000

IPP Rev:B

100 Each

14.0000

10-05-19

2

Location Loc Oty Loc Code WA 14 56990 1 58136 13 100 Each 10.0000

B58525 (1) AM 10/05/12

Location Loc Qty Loc Code ST109 5 57086 5 WA 5 58139

Handle Plate

Thursday, May 13, 2010 10:25:25 AM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | | | | | | | |
|---------|------|--------------------|----------------------|------------------------------|--------------------|--------------|--------|-------------------------------------|--------------------------|--|--|--|--|
| DATE | STEP | PR | PROCEDURE CHANGE | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | |
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| Part No | : | PAR #: | Fault Cate | gory: | _ NCR : Yes | No DQ | A: | Date: | | | | | |
| Rese | | esolution: | Dispositio | n: | _ QA: N/C C | losed: | | Date: _ | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NC | R) | | | | | | | |
| DATE | STEP | Description of NC | | | | Verific | cation | Approval | Approval | | | | |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Date | & Secti | on C | Chief Eng | QC Inspector | | | | |
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Thursday, May 13, 2010 10:25:25 AM

Work Order ID: 58658

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC



IPP Rev:B

Start Date: 5/13/2010

Start Qty: 1.00

Required Date: 5/14/2010

Required Oty: 1.00

Component Item ID/ Item Name D4021-5

Item ID

Replacement Mfg/ Purch Manufactured

Bin **Primary** Item Location No

Location

ST109

Last Location Route Seq ID 150

Unit of Measure Each

Qty on Hand 13.0000 Qty per Kit 2

Qty Issued

SA

Date Issued

10-05-21

Status

Blanking Plate

D4034-041

Cherry Rivets

Manufactured No

Loc Qty Loc Code 13 58140 13 100

Each 5.0000

SM 10/05/17

Aft Upper Rib Assembly

Manufactured No

Loc Oty Location Loc Code WA 5 58141 5 100 Each 5.0000

Fwd Upper Rib Assembly

MS20600-AD4W3 Purchased

No

Location Loc Qty Loc Code WA 5 58142 5 150 1,825.000 Each

Loc Code

SAD 10-05-21

Location Loc Oty ST321 1825 106375 3 107939 822 111636 1000

| | • | | | | | | | | |
|-------------|------|-------------------|----------------------|------------------------------|-------------|--------------|---------------------------------------|-------------------------------------|--------------------------|
| W/O: | | | WC | RK ORDER CHAN | GES | | · · · · · · · · · · · · · · · · · · · | | |
| DATE | STEP | PR | OCEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | · | | | | | | | |
| Part No | | PAR #: | | gory: | NCR: Yes | No DQ | A: | Date: _ | <u> </u> |
| Resolution: | | | Disposition | n: | QA: N/C (| Closed: | | Date: _ | |
| NCR: | | | WORK ORDE | R NON-CONFORM | IANCE (NC | R) | | | |
| DATE | STEP | Description of NC | | | ction B | Verifi | cation | Approval | Approval |
| | 0.2. | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Dat | & Sect | ion C | Chief Eng | QC Inspector |
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Picklist Print

Thursday, May 13, 2010 10:25:25 AM

Page 6

Work Order ID: 58658

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC

Start Date: 5/13/2010

Start Qty: 1.00

Required Date: 5/14/2010

Required Qty: 1.00

Component Item ID/ Item Name MS21042L3

Replacement Mfg/ Item ID

Purch Purchased Bin Primary Location Item No

No

Last Location Route Seq ID 150

Unit of Measure Each

Qty on Hand 1,561.000

Loc Code

Qty per Kit

Issued

Issued

Date

Status

10-05-21

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IPP Rev:B

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SAY 10-05-21

Purchased

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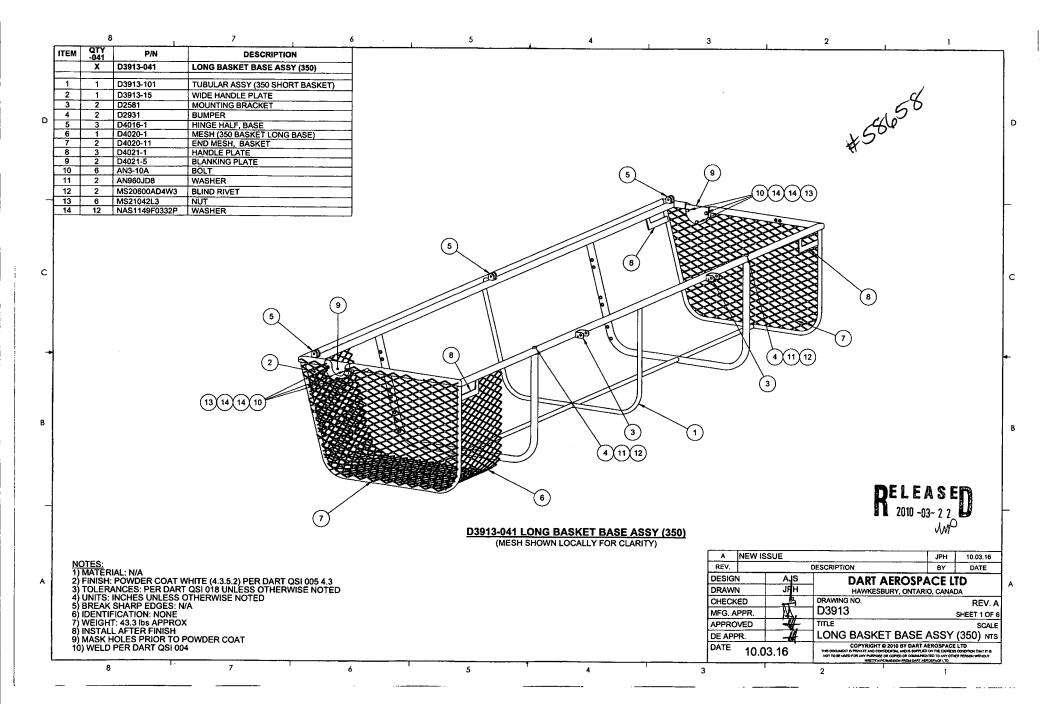
NAS1149F0332P

Location Loc Qty ST275 887 18057 887 Loc Code

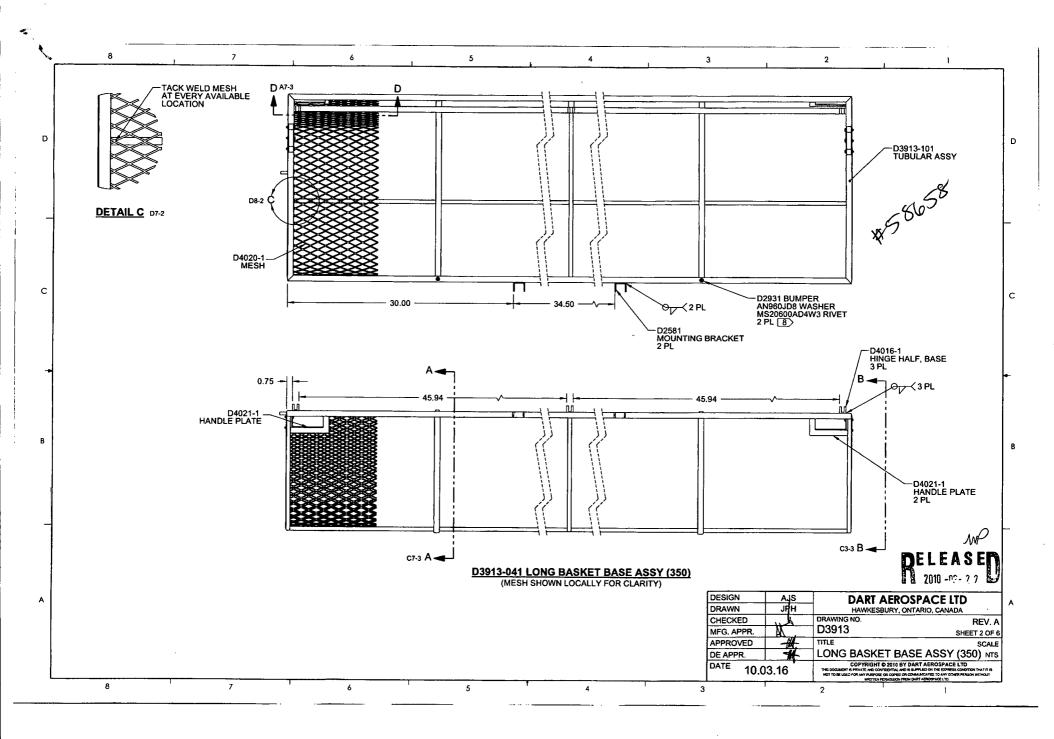
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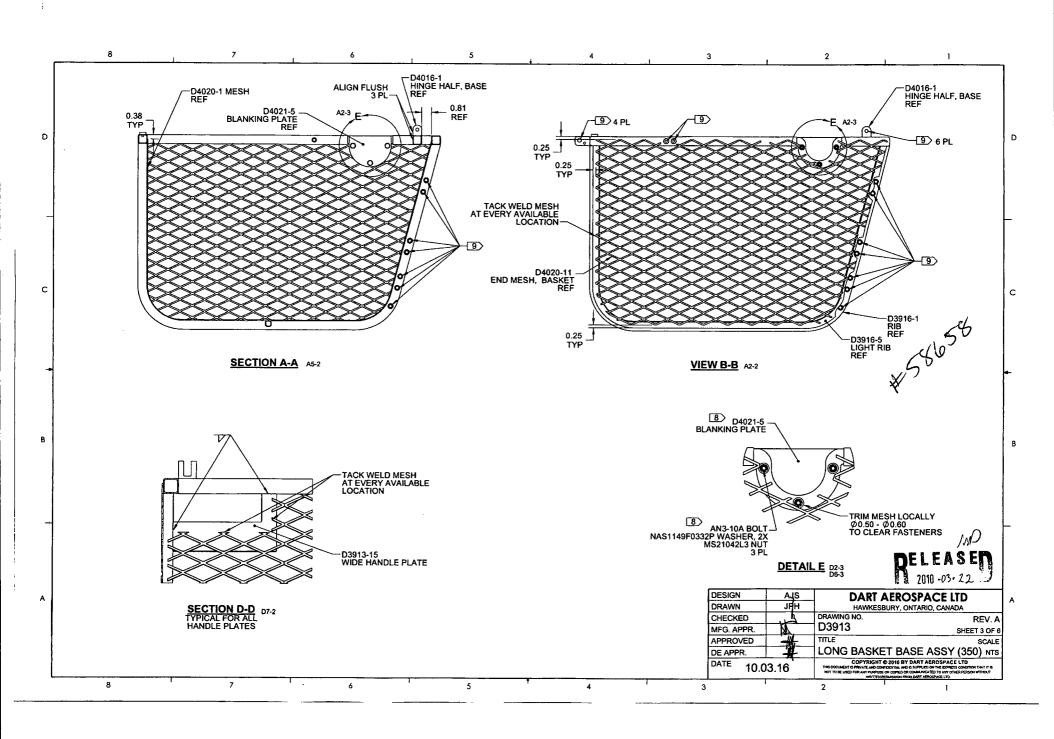
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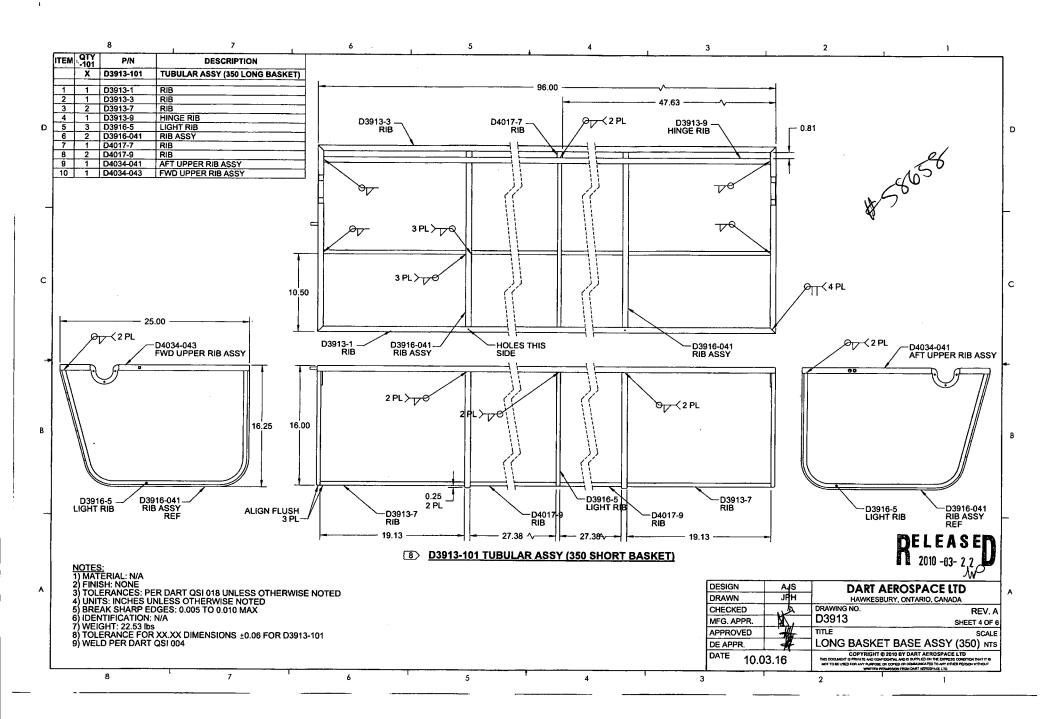


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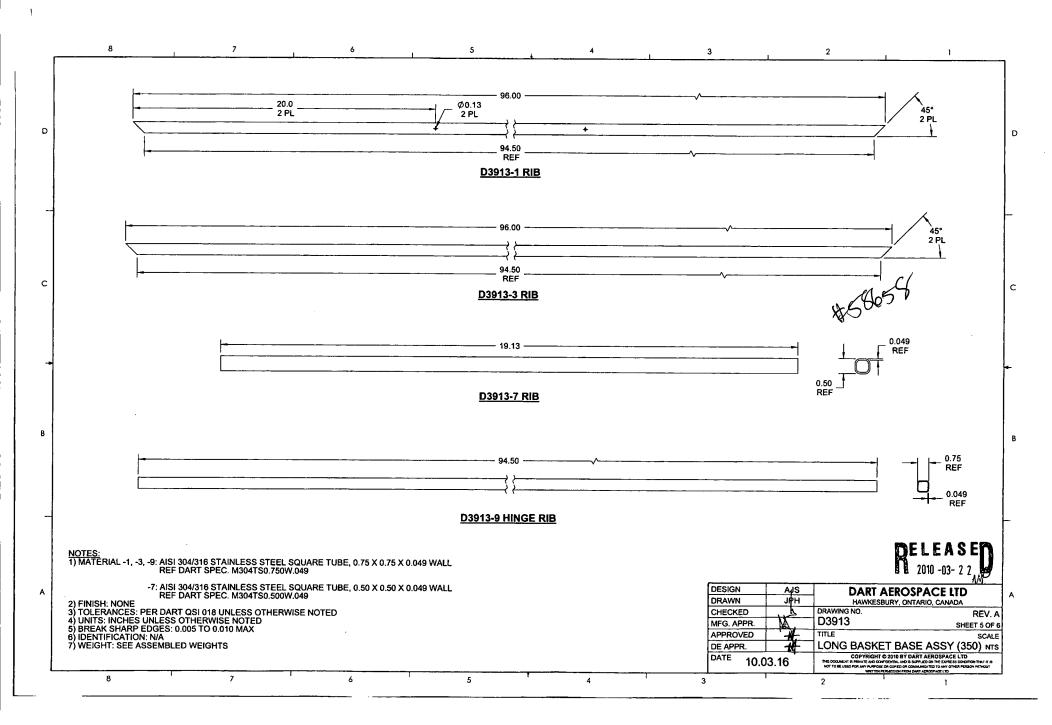
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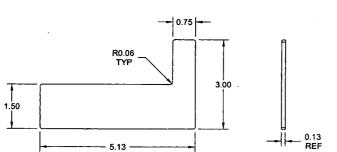


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D3913-15 WIDE HANDLE PLATE

NOTES: 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

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| DESIGN | AJS | DART AEROSPACE LTD | | |
|------------|------|---|--|--|
| DRAWN | JFH | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | .,, | DRAWING NO. REV. A | | |
| MFG. APPR. | Μ. | D3913 SHEET 6 OF 6 | | |
| APPROVED # | | TITLE SCALE | | |
| DE APPR. | 4# | LONG BASKET BASE ASSY (350) NTS | | |
| DATE 10.0 | 3.16 | CEPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOUARDIT S PRIVATE AND CONTRIBUTION, AND IS SUPPLIED OF THE DIFFICES CREATION THAT IT IS NOT TO BE USED FOR ANY PARFORD OR CONTRIBUTION OF THE DIFFICES WITHOUT THAT IT IS NOT TO BE USED FOR ANY PARFORD OR CONTRIBUTION OF THE DATE OF THE PRISON WITHOUT WITHOUT THE DESIGNATION OF THE DATE OF THE DATE OF THE DATE OF THE OFFICE OFFICE OF THE OFFICE OF THE OFFICE OF THE OFFICE OFFICE OF THE OFFICE | | |

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| DATE | | Description of NC | | Corrective Action Section B | | | | | | |
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